

Date: Wednesday, 12/7/2005 12:45:28 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WHEEL SHAFT R22/R44
<b>Job Number</b> : 25167	
<b>Estimate Number</b> : 11267	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D33571
<b>This Issue</b> : 12/7/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3357 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 1/10/2006
<b>Checked &amp; Approved By</b> : <u>SEE COMMENT BELOW</u>	<b>Qty:</b> 22 <b>Um:</b> Each
<b>Comment</b> : Est Rev:A 05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M174R1000	17-4PH SS ROUND BAR 1.00
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**Comment:** Qty.: 0.4809 f(s)/Unit Total: 9.6180 f(s)  
17-4PH SS ROUND BAR 1.00  
(M174R0100)  
Batch: M19430

ML 06/01/27

22

PTO

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA503 and Dwg D3357

2-Deburr

ML 06/01/27

22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/01/27

22

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Mill as per Dwg D3357

ML 06/01/27

22

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

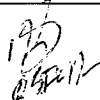
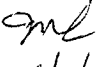

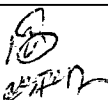

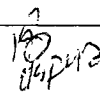
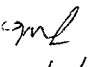
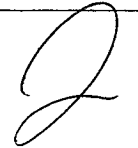
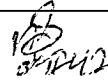

ML 06/01/27

22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 06/01/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/26	2	1. one piece scrap the final dim too small.		destroy and replace	 06/01/22	 06-01-31		 06-01-30
		2. one piece scrap. the thread was wrong						
06/01/26	2	3. one piece scrap. wrong thread too deep		destroy and replace	 06/01/22	 06-01-31		 06-01-31

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL SHAFT R22/R44

Job Number: 25167

Part Number: D33571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/01/31 22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 420

C206/01/31 22

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

19 06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

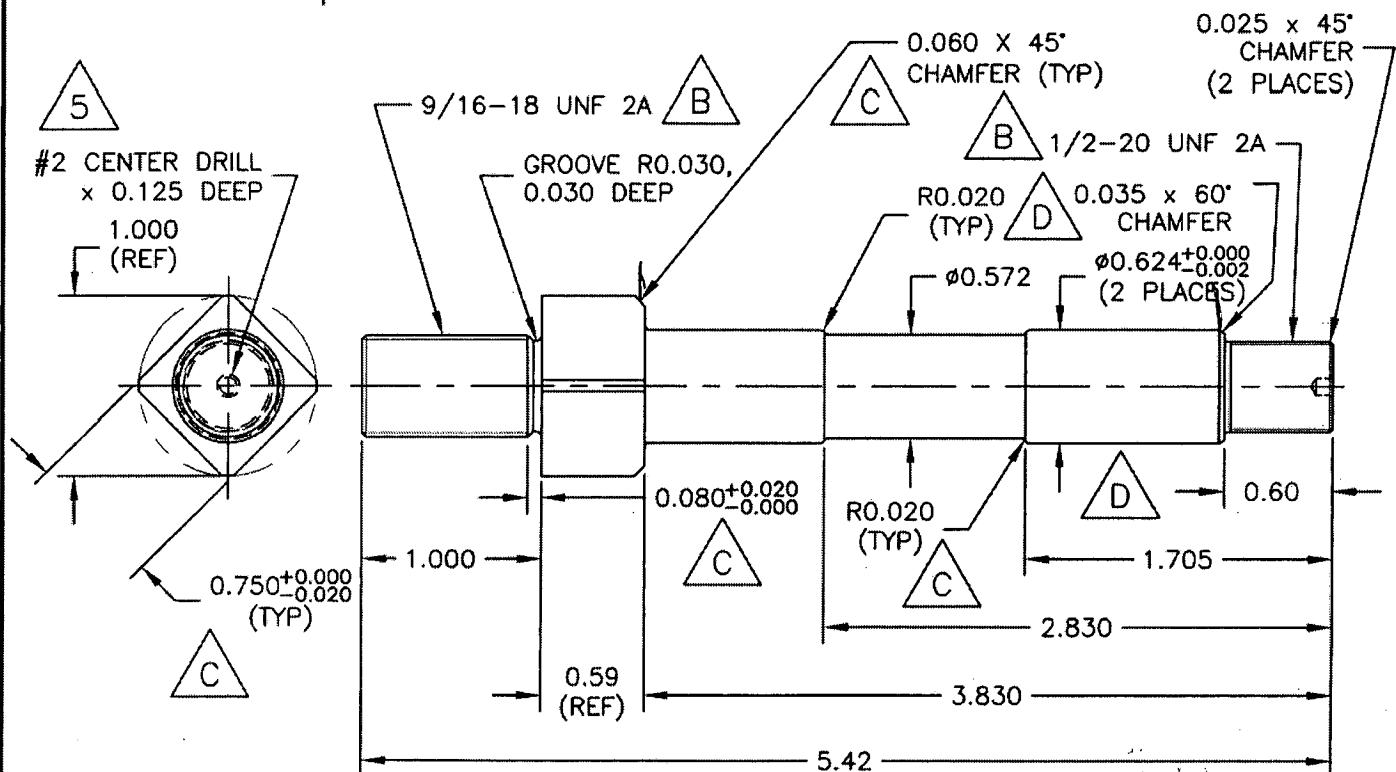
**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3357	REV. D SHEET 1 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.05.27	ADD THREAD SPEC & 0.063; 17-4 PH ROUND WAS 303 HEX SS	
C	05.07.21	0.750 WAS 0.625; 0.100 WAS 0.063	
D	05.12.02	Ø0.624 WAS Ø0.623; 0.60 WAS 0.71	

RELEASED  
*[Signature]*  
05/12/02



**D3357-1 R22/R44 WHEEL SHAFT**

**NOTES:**

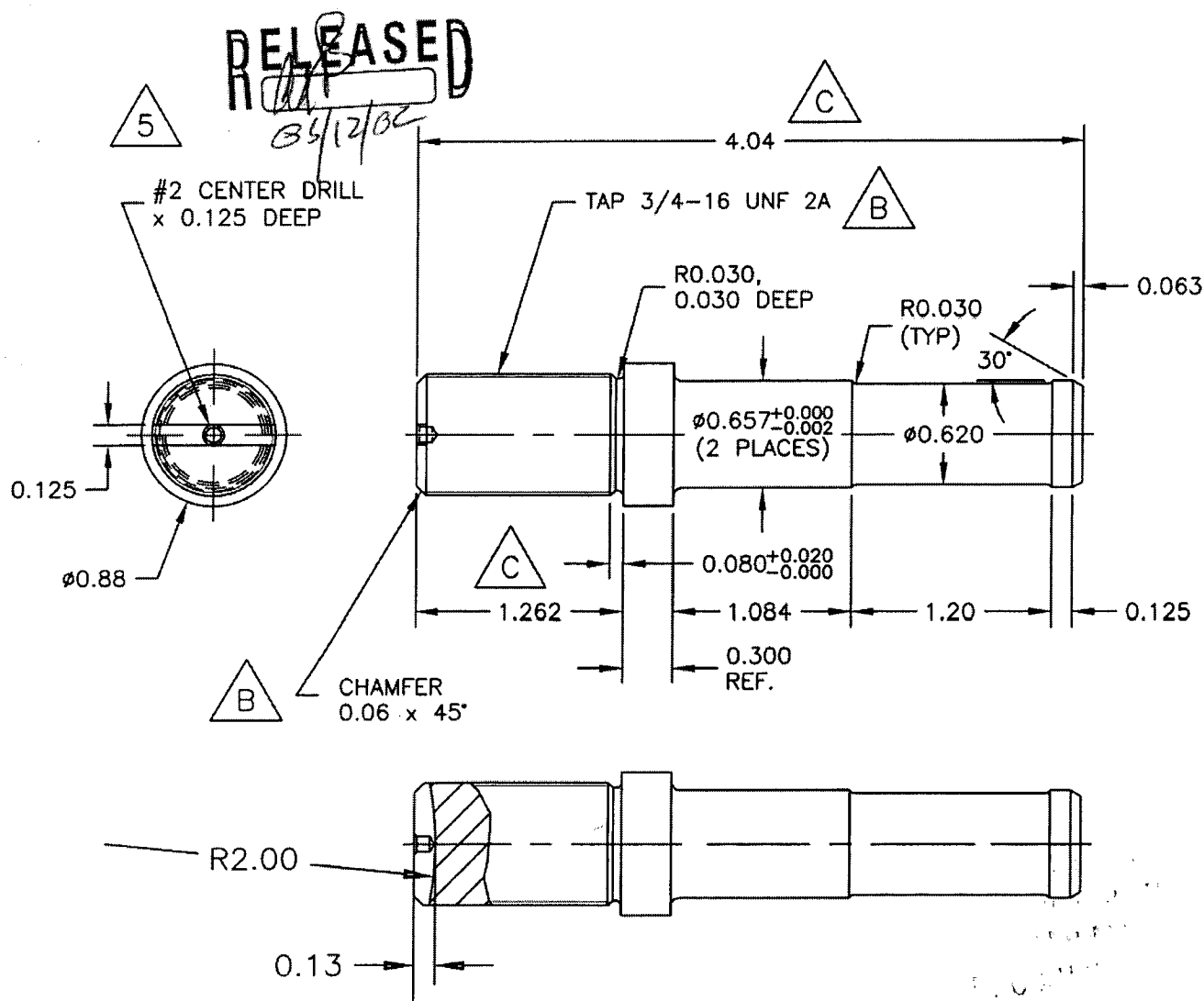
- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900 (REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3357	REV. D SHEET 2 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1



### D3357-3 R22 LOCK SHAFT

#### NOTES:

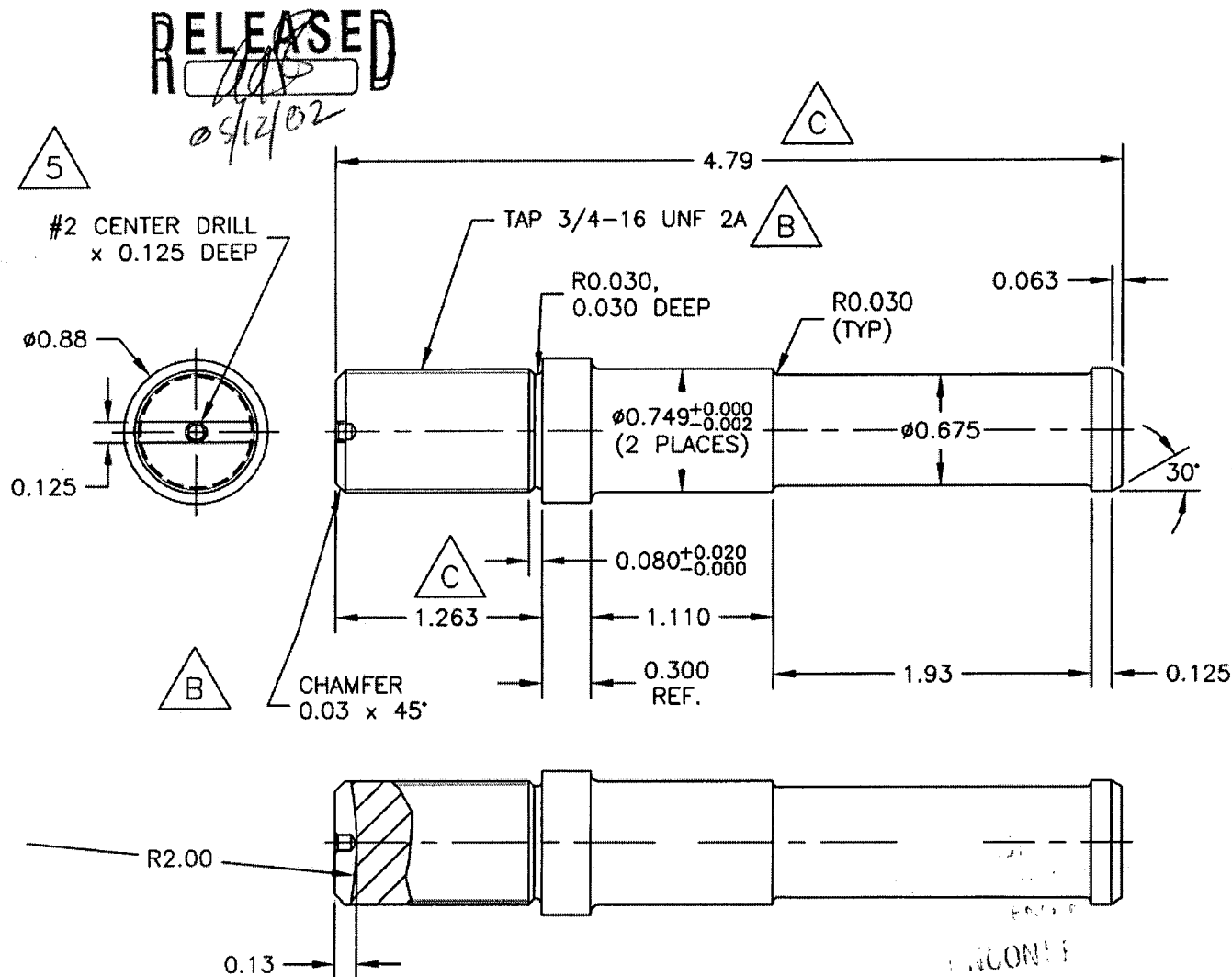
- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900 (REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3357	REV. 0 SHEET 3 OF 3
DATE 05.12.02		TITLE SHAFTS	SCALE 1:1



### D3357-5 R44 LOCK SHAFT

#### NOTES:

- 1) MATERIAL: 17-4 PH ROUND BAR STAINLESS STEEL CONDITION H900  
(REF. DART SPEC. M17-4-R1.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) CENTER DRILL AS REQUIRED

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